

Date: Thursday, 02/04/2009 2:22:42 PM
User: Julie Dawson

Process Sheet

| | | | |
|-----------------------|--|------------------|------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : FRAME |
| Job Number | : 46824 | | |
| Estimate Number | : 13826 | | |
| P.O. Number | : | Part Number | : D22521 |
| This Issue | : 02/04/2009 S.O. No. : | Drawing Number | : D2252 REV G |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : / / Type : LARGE FAB ASSY | Drawing Revision | : G |
| Previous Run | : | Material | : |
| Written By | : | Due Date | : 14/04/2009 Qty: 8 Um: Each |
| Checked & Approved By | : <u>JUD 09.04.08</u> | | |
| Comment | : Est Rev:A 09.03.18 New Issue EC verified by:DD | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | | |
|-------|----------------|----------------|---------------------------|
| ✓ 1.0 | M304TS0750W065 | Scrap 1.5(f.s) | 304 SQ Tube .75x.75x.065W |
|-------|----------------|----------------|---------------------------|



Comment: Qty.: 2.2313 f(s)/Unit Total : 17.8500 f(s)

304 SQ Tube .75x.75x.065W

batch: M11331

SAD

09-04-08

| | | |
|-----|-------------|------------------------------|
| 2.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|



Comment: LARGE FABRICATION RESOURCE 1

1- Cut as per dwg D2252

2- Deburr and remove identification markings on tube

SAD 09-04-08 (2)

| | | |
|-----|-----|------------------------------|
| 3.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

SAD 09/04/08 (18)

| | | |
|-----|-------------|-----------------------|
| 4.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

SAD 09-04-08 (8)

| | | |
|-----|------|------------------------------|
| 5.0 | QC21 | FINAL INSPECTION/W/O RELEASE |
|-----|------|------------------------------|



Comment: FINAL INSPECTION/W/O RELEASE

SAD 09/04/08

Job Completion



MF 09-04-08

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| ITEM | QTY -041 | QTY -043 | PART NUMBER | DESCRIPTION |
|------|-------------|-------------|-------------|------------------|
| 1 | X | | D2252-041 | BASKET ASSEMBLY |
| 3 | | X | D2252-043 | LID ASSEMBLY |
| 7 | 2 | 2 | D2221-1 | RIB |
| 8 | 5 | | D2235-1 | RIB |
| 9 | 2 | 2 | D2252-1 | FRAME |
| 10 | | 2 | D2252-7 | FRAME |
| 11 | 1 | | D2252-9 | FRAME |
| 12 | 1 | | D2252-11 | FRAME |
| 13 | 1 | | D2252-13 | FRAME |
| 14 | 1 | | D2252-15 | FRAME |
| 15 | 4 | | D2252-17 | FRAME |
| 16 | | 1 | D2252-23 | FRAME |
| 17 | 2 | | D2253-1 | LUG |
| 18 | 2 | | D2254 | GUSSET |
| 19 | 1 | 1 | D2327-3 | BUSHING |
| 20 | | 1 | D2329 | LABEL PLATE |
| 21 | 4 | 2 | D2581 | MOUNTING CHANNEL |
| 22 | | 2 | D2989-19 | RIB |
| 23 | 3 | | D3748-1 | HINGE HALF |
| 24 | | 3 | D3749-1 | HINGE HALF |

G

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NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELDING: PER DART QSI 004

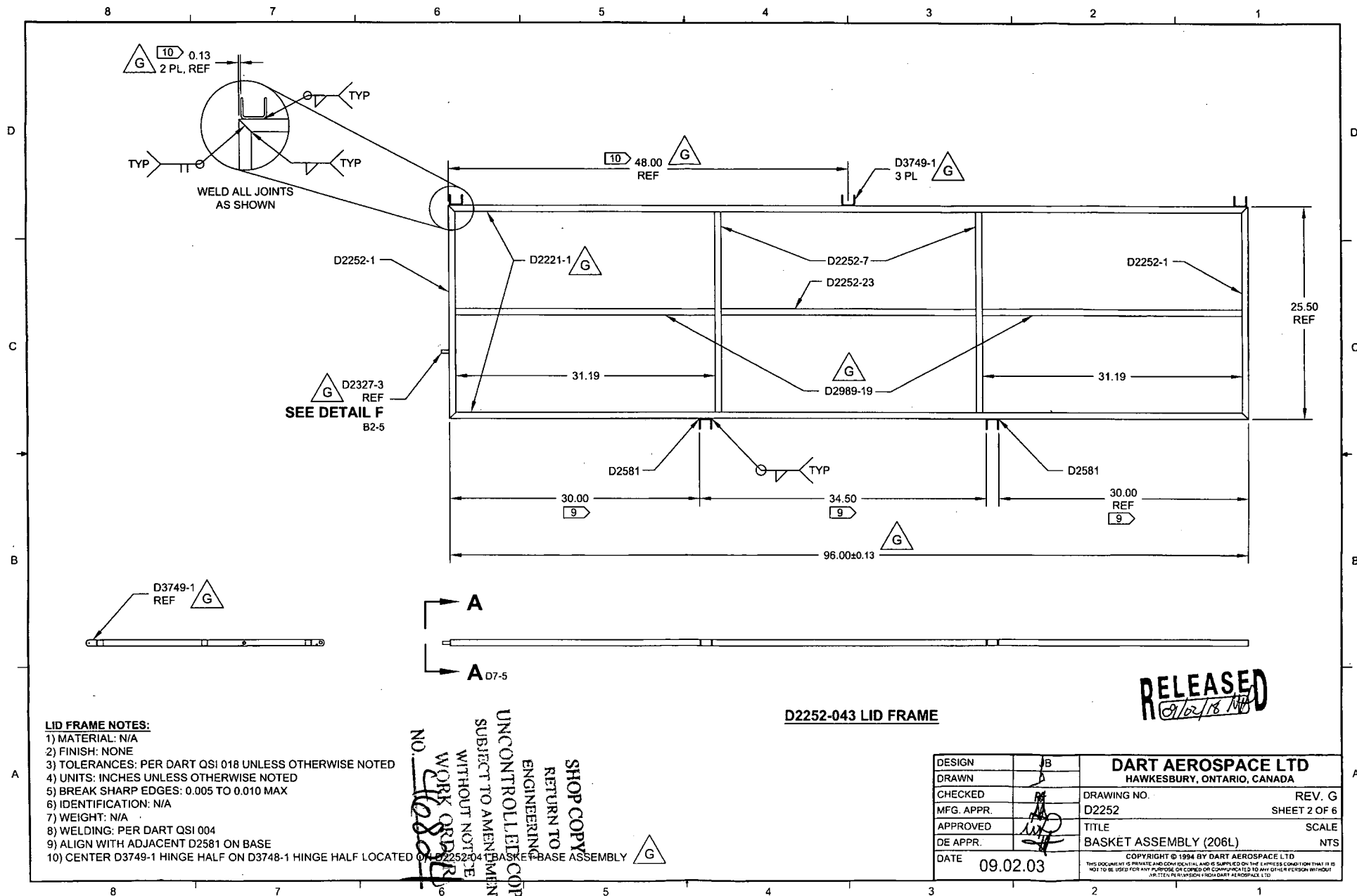
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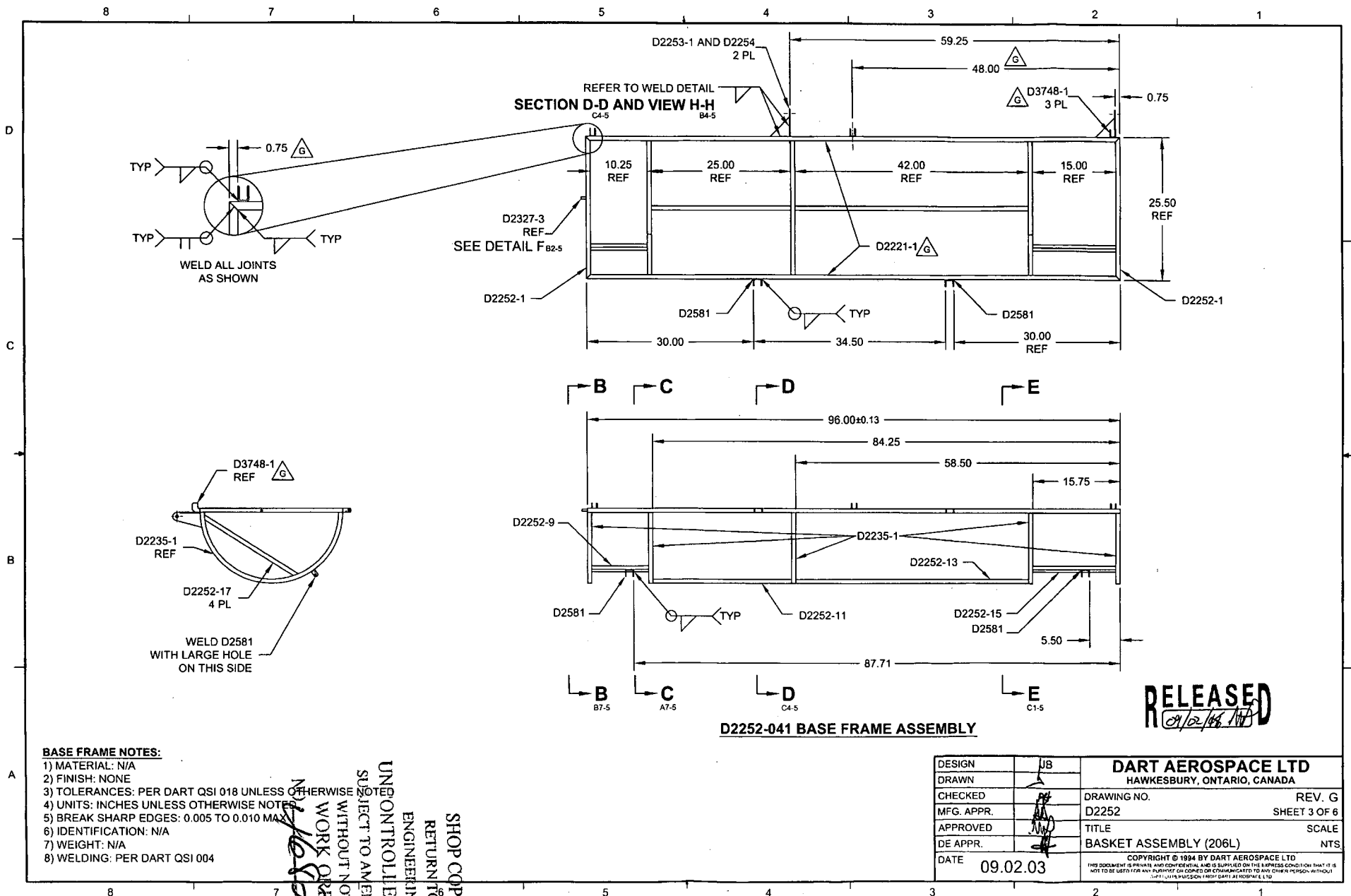
| G | ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 23 AND 24 REPLACE D2232-1/-3; STRETCHED LID FROM 95.27" TO 96.00"; ITEM 7 REPLACES D2252-3/-19; ITEM 19 (ON LID) REPLACES D2327-1; ITEM 22 REPLACES D2252-21; UPDATED TOOLING (ZN A6-5). P/N REASON: SEE PAR#09-006. | MB | 09.02.03 |
|------------|---|-----|----------|
| F | DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. SHT 2 VIEWS INVERTED FOR CLARITY. FRAME MATERIAL THICKNESS WAS 0.080. | AJS | 08.08.11 |
| E | INCORPORATED D1 & D2. ADDED D2231-1/-3 & D2252-19. | MB | 05.11.10 |
| D | MODIFIED LATCH, D2581 WAS D2255-3 | BK | 99.09.14 |
| C | RE-DRAWN | BK | 95.12.11 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | JB | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 09.02.03 | | |

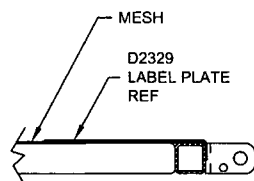
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2252
REV. G
SHEET 1 OF 6
TITLE BASKET ASSEMBLY (206L)
SCALE NTS

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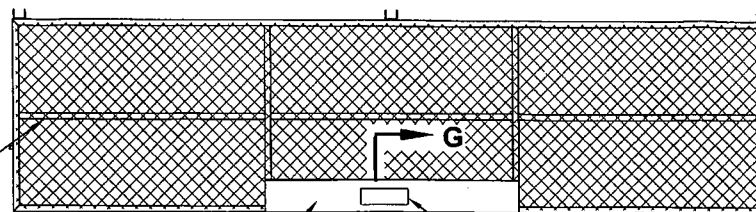






SECTION G-G
ROTATED 90° CCW

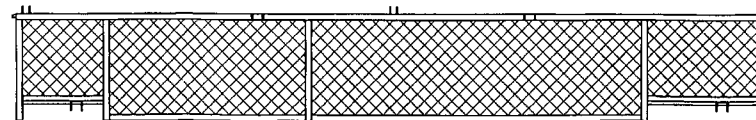
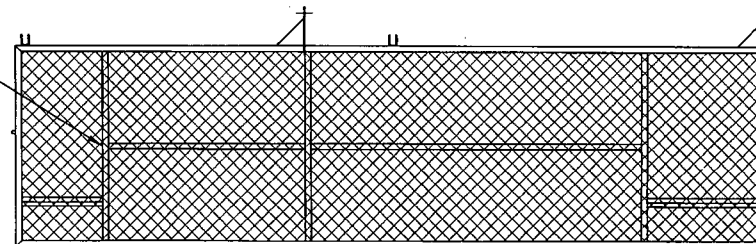
TACK WELD EACH
STRAND END OF
STEEL MESH TO FRAME



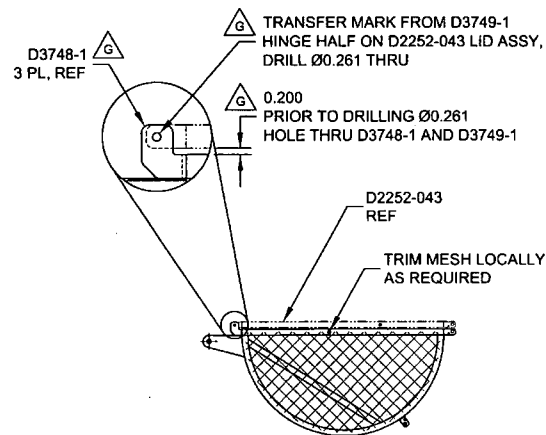
D2329 LABEL PLATE
CENTER ON THE
BASKET LID

REMOVE 2" X 6" SECTION
OF MESH FROM BEHIND
LABEL PLATE

D2252-043 LID ASSEMBLY



D2252-041 BASE ASSEMBLY



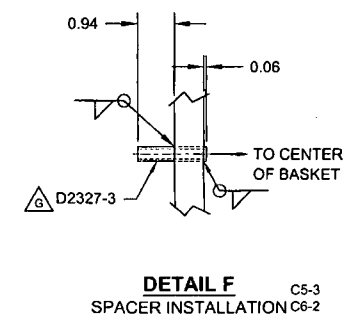
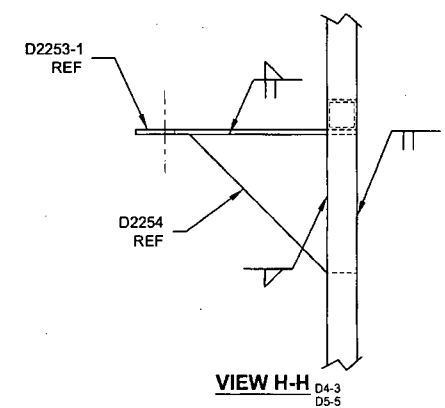
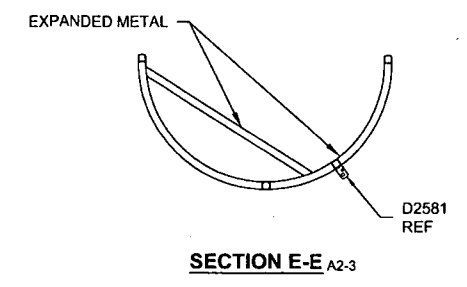
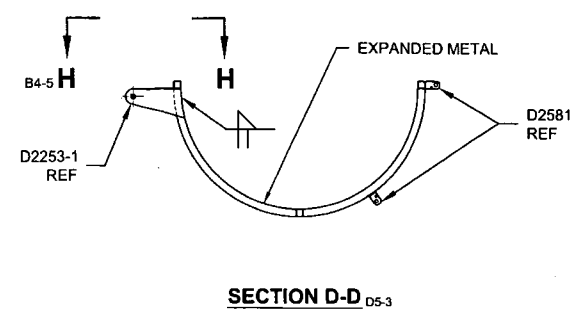
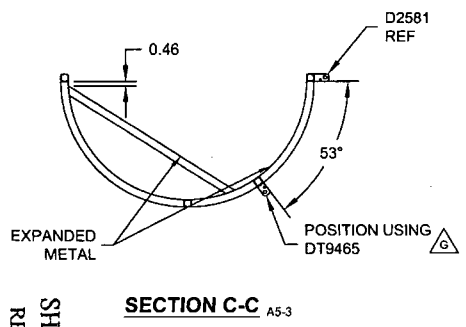
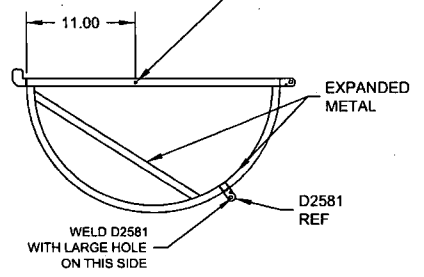
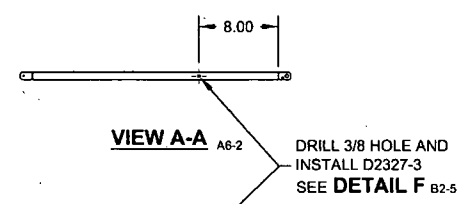
ASSEMBLY NOTES:

- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004






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| CHECKED | | DRAWING NO. | REV. G |
| MFG. APPR. | | D2252 | SHEET 4 OF 6 |
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| DE APPR. | | BASKET ASSEMBLY (206L) | NTS |
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8 7 6 5 4 3 2 1



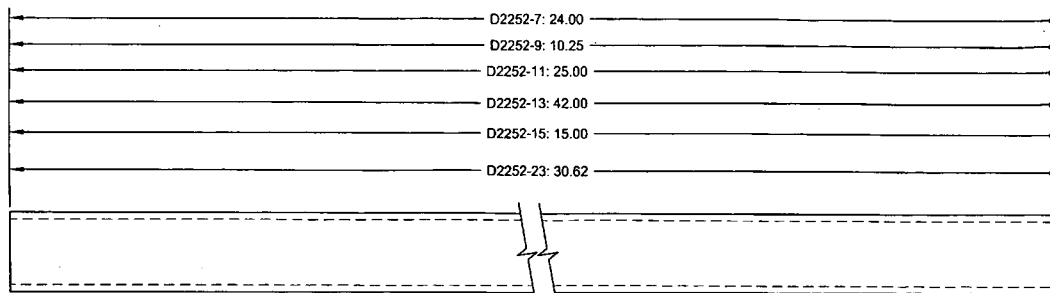
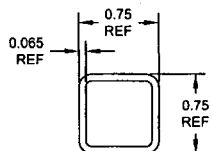
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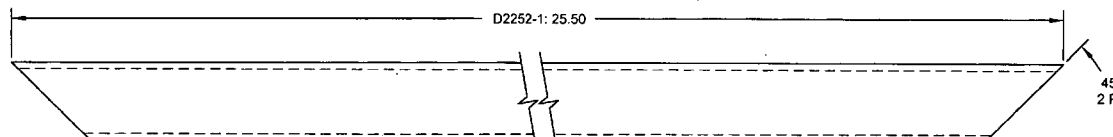
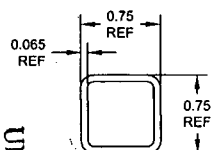
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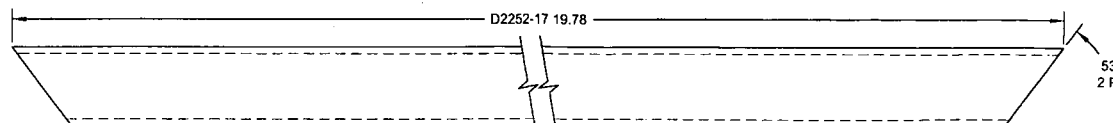
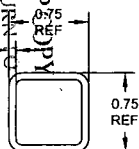
8 7 6 5 4 3 2 1



D2252-7 FRAME
D2252-9 FRAME
D2252-11 FRAME
D2252-13 FRAME
D2252-15 FRAME
D2252-23 FRAME








D2252-1 FRAME



D2252-17 FRAME

RELEASED
2/2/81

- NOTES:**
- 1) FRAME MATERIAL: SEE SHEET 1
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

| | | | |
|---|---|--|--------------|
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| MFG. APPR. |  | D2252 | SHEET 6 OF 6 |
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